

Work Order ID 71309

Tuesday, June 28, 2011 8:53:10 AM



Page 1

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11-06-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Le 11-06-28
DP

B
11/06/28
1 0 3E11/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71309

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Page 2

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Web

Start Date: 6/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BEH/06/28

140

Identify as per dwg & Stock Location: hls

0.00



Packaging

Memo

0.00

Packaging

1 B 11/06/28

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 JH

MF
11-06-28

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 28, 2011 8:53:16 AM

Page 1

Work Order ID: 71309

Parent Item: D2654-5

Parent Item Name: Web



Start Date: 6/28/2011

Required Date: 7/26/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-7-140

Manufactured

No

100

Each

11.0000

1



EXT. "I BEAM" THICK



1

B 11/06/28

Location

Loc Qty

Loc Code

LG

11

21966

1

41591

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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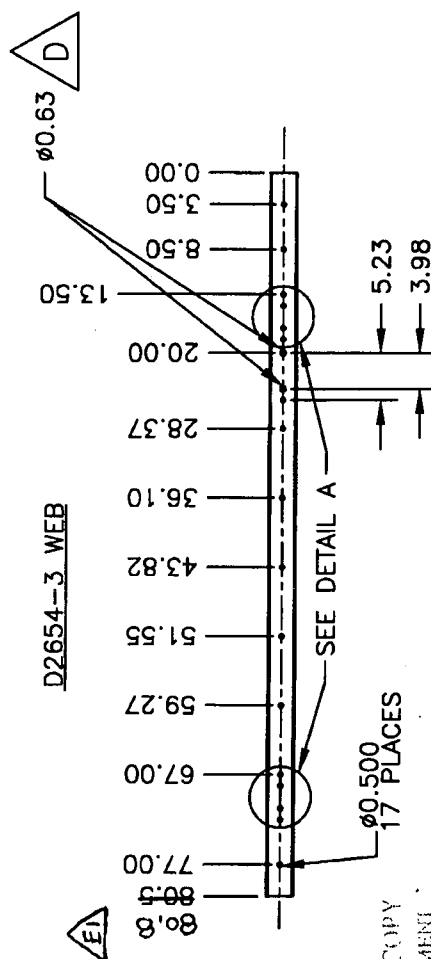
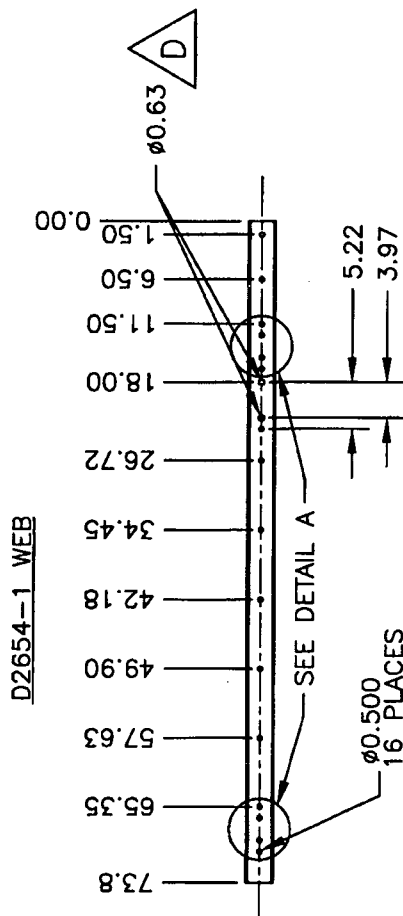
NOTE: Date & initial all entries

DART
DEO ATTACHED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71309

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

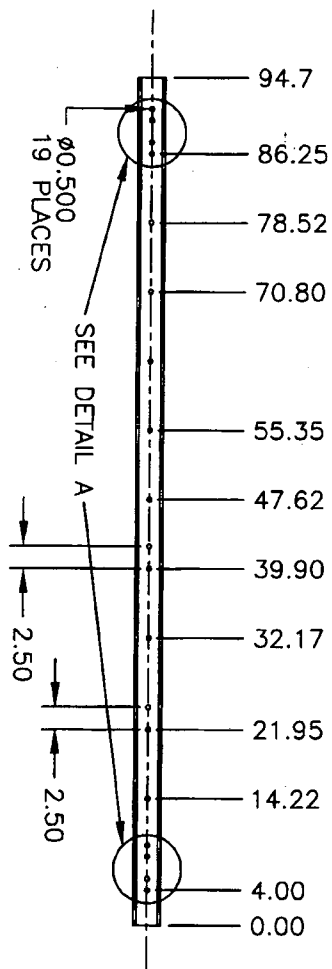
W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



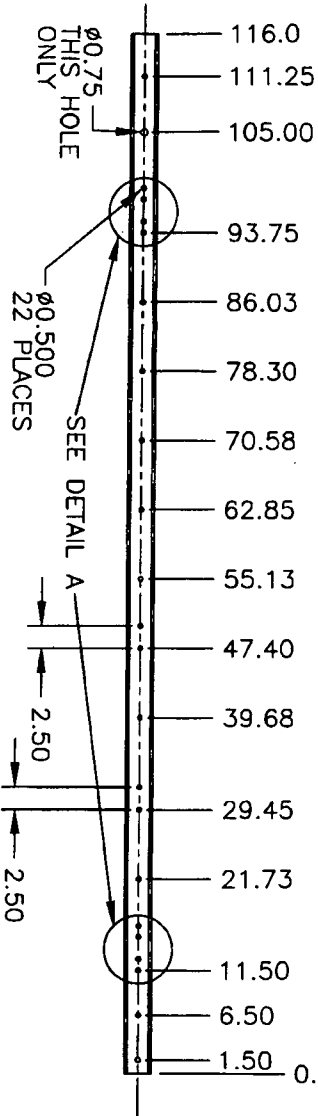
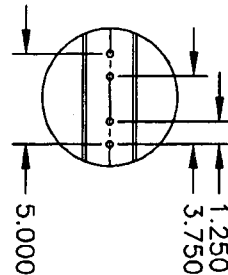
D2654-5 WEB

W/0 71309

DEF ATTACHED

RELEASED

DETAIL A
SCALE 1:10



D2654-7 WEB

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	APPROVED	DATE	04.05.26
DRAWN BY	APPROVED	TITLE	WEB
DART AEROSPACE USA, INC.	DART AEROSPACE USA, INC.	SCALE	1:20
PORT HADLOCK, WA	D2654	SHEET 2 OF 2	REV. E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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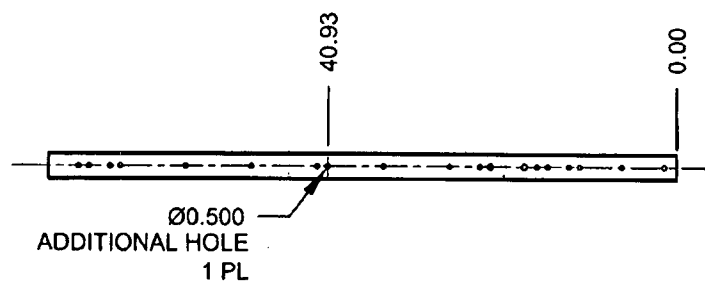
NOTE: Date & initial all entries

DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

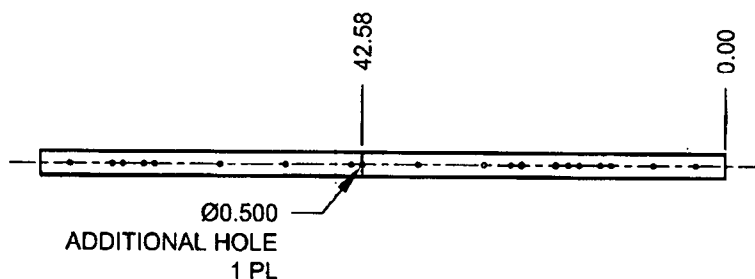
DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*

W/0 71309



D2654-1 WEB



D2654-3 WEB

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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